

Work Order ID 53343

November 2, 2009 8:14:15 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 02/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: PL

Date: 04-11-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3929	rev A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 9-11-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-11-3



Work Order ID 53343




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Page 2

Item ID: D3929-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Gusset Assembly
Start Date: 02/11/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>27 8 02/11/09</i>			<i>(63)</i>	<i>f</i>		
130  Packaging Packaging	Pick Kit Memo	0.00 0.00				<i>Sp</i>	<i>09</i>	<i>11</i>	<i>05</i>
140  Large Fab Large Fab	 Memo Weld bushings D3907-1 as per dwg D3929 316L rod batch: <i>m108775</i>	0.00 0.00							<i>Sp 09.11.05</i> <i>(81)</i>

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Item ID: D3929-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 02/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Cpl 09 11 05

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

27 Sorullos

Ⓟ

170



Packaging

Packaging

Identify as per dwg & Stock Location: Basket

0.00

Memo

0.00

ID 09.11.05

Ⓟ



Work Order ID 53343


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Item ID: D3929-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Gusset Assembly
Start Date: 02/11/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21 - Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/11/06 
MF
09-11-06

Picklist Print

Page 1

November 2, 2009 8:14:19 AM

Work Order ID: 53343



Parent Item: D3929-042RevA



Parent Item Name: Gusset Assembly



Start Date: 02/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	138.9951	2.8421	32894		
												

18911-3

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

138.9950979

111018

10.9950979

112663

128

111018

D3907-1RevA

Manufactured

No

130

Each

44.0000

12.0000



Bushing

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

44

50944

4

53138

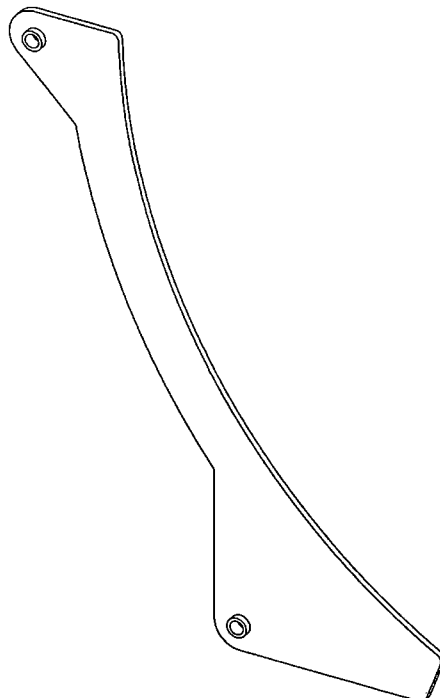
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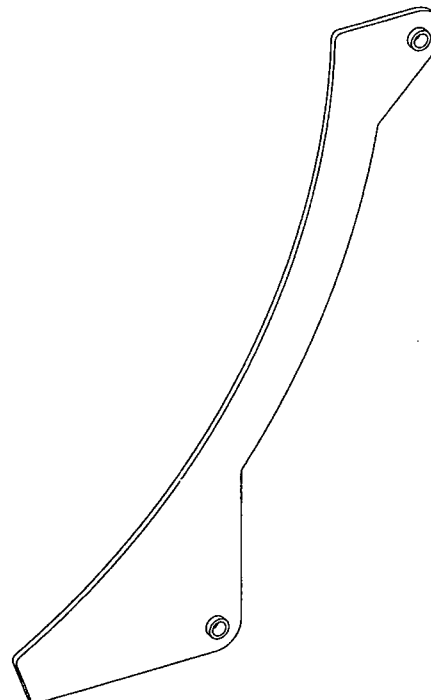
16.

SP 09.11.05

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOPLIST
REFURBISHED
ENGINE
UNCONTROLLED
SUBJECT TO A
WARRANTY
WORK ORDER
NO. 53343
P0911-2

RELEASED
8/16/12 MD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

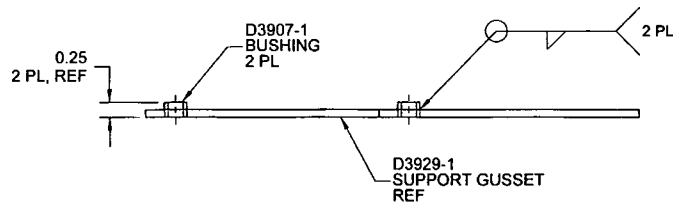
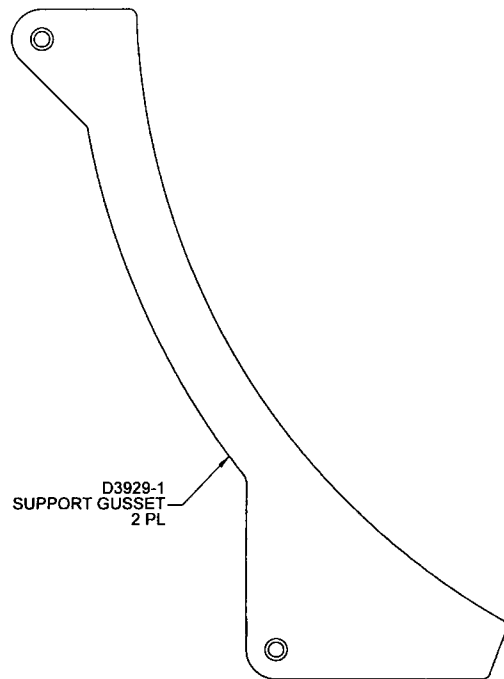
REV.	NEW ISSUE	DESCRIPTION	MB	09.04.03
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

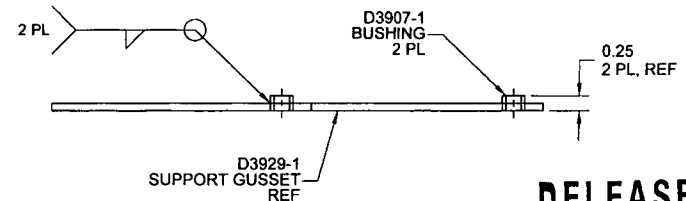
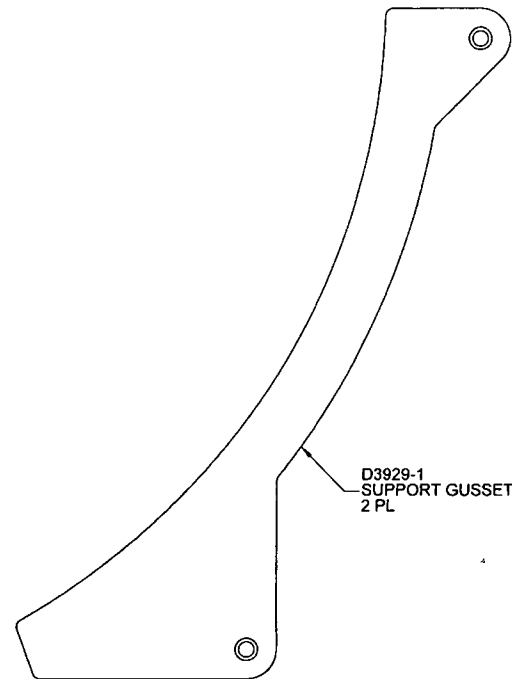
DRAWING NO. REV. A
D3929 SHEET 1 OF 3
TITLE SCALE
GUSSET ASSEMBLY NTS

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STRUCTURE
 REFERENCE
 ENGINE
 UNCONTROLLED
 SUBJECT TO
 WITHIN
 WORK
 NO. 58843



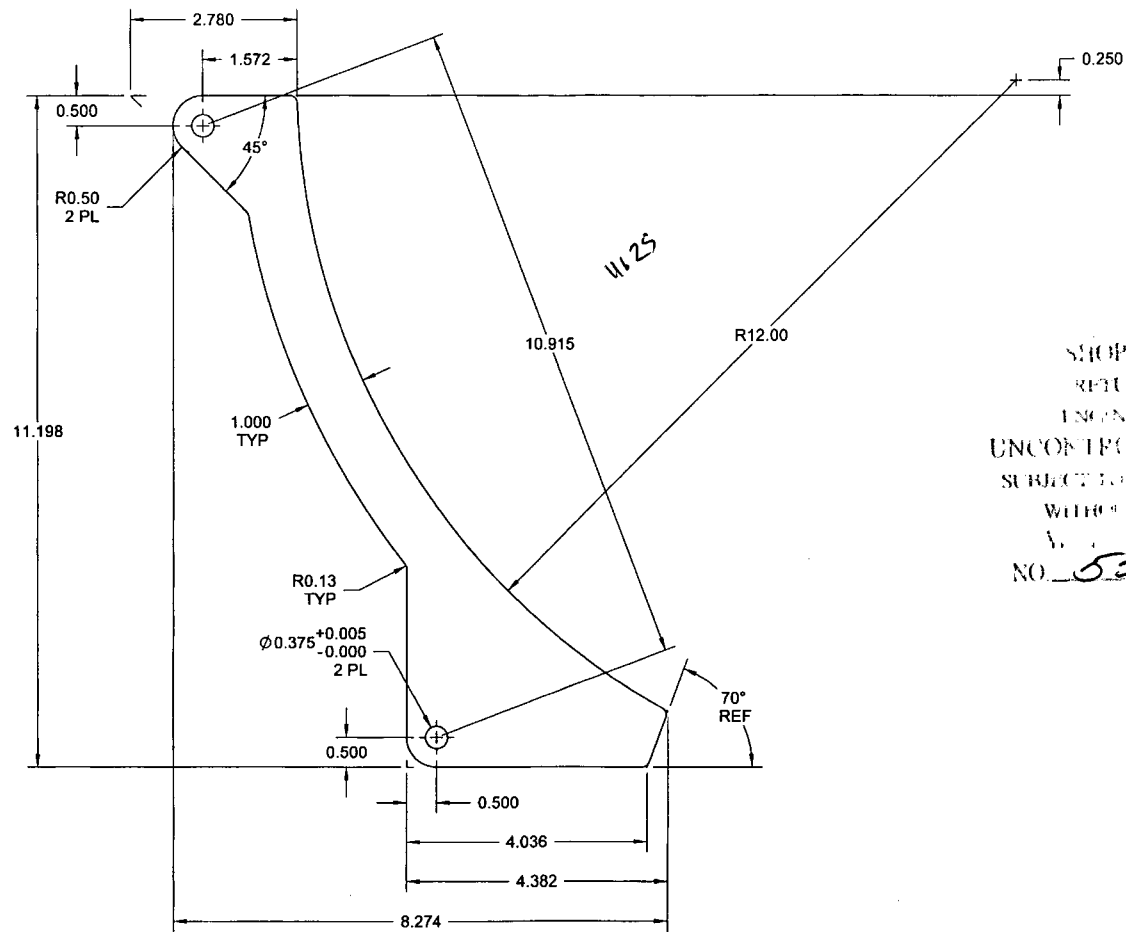
D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
 09/04/22

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MFG. APPR.		D3929	SHEET 2 OF 3
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DE APPR.		GUSSET ASSEMBLY	NTS
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D3929-1 SUPPORT GUSSET

SHOPLUG
RETURNED
UNCONTROLLED
SUBJECT TO
WITH
NO. 53343

RELEASED
09/04/03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.72 lbs

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